

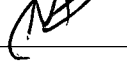
Work Order ID 126926

Monday, December 01, 2014 11:33:35 AM

126926

Page 1

Item ID: D3823-1KGY Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Overhead Rear, LH-Grey
 Start Date: 11/27/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/02/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan:  Date: 14-12-01 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3823-1	Rev C

100		0.00							DAG 07 9-89
-----	--	------	--	--	--	--	--	--	-------------------

100

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

14/12/08

105

0.00

105

HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 KYDEX

DAG
07
9-89

14/12/08

Temp: 150 deg. F
 Time IN: 5:00 PM
 Time OUT: 6:00 AM
 DEC 07 2014
 Per.....

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Item ID: D3823-1KGY

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Overhead Rear, LH-Grey

Stop ***NS2***

Start Date: 11/27/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/02/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							07 9-89
110									
Thermoform	Memo	0.00							
Thermoforming Machine	1-Machine Set-Up								
	2-Pre-heat Tool to required temp.								
	3-Thermoform as per Dwg and Folio #FTA030 using tool DT9112								
	Dwg Rev: <u>C</u>								
	Folio Rev: <u>B</u>								
	Visually inspect for proper formation and texture								
140		0.00							DAS 07 9-89
140									
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	1-Trim to finished dimensions as per Dwg								
150	QC2- Inspect parts off machine FAI/FAIB	0.00							DAS 07 9-89
150									
QC	Memo	0.00							
Quality Control	Complete FAI document								

17/12/08

17/12/16

17/12/16

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Item ID: D3823-1KGY Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Overhead Rear, LH-Grey
 Start Date: 11/27/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/02/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
160									
QC	Memo	0.00							
Quality Control									

DEC 18 2014

170	Identify as per dwg & Stock Location: _____	0.00							
170									
Packaging	Memo	0.00							
Packaging									

DAS
38
9-89

DEC 18 2014

180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

14/12/18 JF

mf

14-12-18

Picklist Print

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Page 1

Work Order ID: 126926

126926

Parent Item: D3823-1KGY

D3823-1KGY

Parent Item Name: Overhead Rear, LH-Grey

Start Date: 11/27/14

Required Date: 12/02/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
Add Step 105 Dry Material 10/04/21 DL

Ipp Rev. B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3-52068		Purchased		No		100	sf	3,800.000	11.15	12			

MKYD6185S 080-P3-52068

**

Kydex steel grey (52"x96"-.080)

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LAIRD	1180	
m129546	347	
m129760	347	
m130383	486	
therm	2620	
119476	61	
121902	819	
122181	1046	
m127759	347	
m128321	347	

14/12/08

12 sp H-

DART AEROSPACE LTD		Work Order:	126926
Description: Rear Overhead, LH		Part Number:	D3823-1KIV/KGY
Inspection Dwg: D3823	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "				
Shape Definition				
Texture Retention				
Material imperfections such as bumps, cracks, voids, scratching				

Measured by: **DAS**
07
9-89

Date: 14/12/08

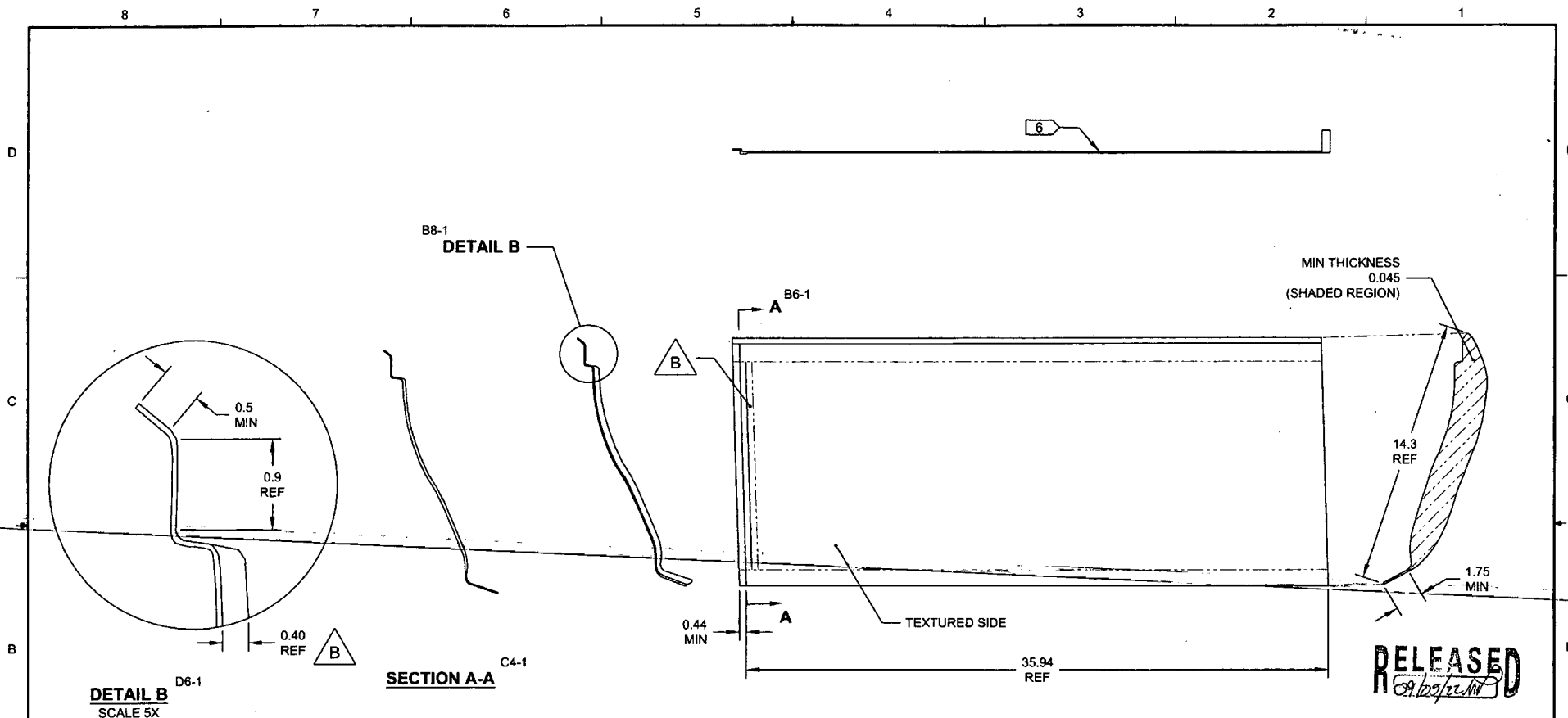
TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.5	Min	0.622"	✓			
0.44	Min	0.55"	✓			
1.75	Min	1.82"	✓			
0.045	Min	0.065"	✓			
0.055	Min	0.075"	✓			

Measured by: **DAS**
07
9-89
Audited by: **DAS**
38
9-89
Prototype Approval: **N/A**

Date: 14/12/17
Date:
DEC 18 2014
Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.06.26	New Issue	KJ	



D3823-1 REAR OVERHEAD, LH

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 1.9 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9112 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.055" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3823-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3823-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

C	ADD STEEL GRAY COLOUR OPTION, ADD IVORY P/N'S D3823-1/2-3(KIV) AND ADD STEEL GRAY P/N'S D3823-1/2-3(KGY) (ZN A5-1, A5-2, A5-3)	PH	09.05.05
B	ADD JOGGLE TO D3823-1/2-3 FOR BETTER FIT WITH D3824-1/3 HAT BIN (ZN C5-1, C5-2, C8-3); 0.40 WAS 0.18 (ZN B7-1, D7-2); 0.45 WAS 0.29 (ZN B8-3)	PH	09.02.09
A	NEW ISSUE	PH	08.09.26
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.05.05		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. C
D3823 SHEET 1 OF 3
TITLE SCALE
REAR OVERHEAD NTS

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